

Date: Friday, 04/04/2008 9:22:03 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	CAP
Job Number :	38395		
Estimate Number :	10519		
P.O. Number :		Part Number :	D2855
This Issue :	04/04/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2855 REV. A
First Issue :	/ /	Project Number :	N/A
Previous Run :	37570	Drawing Revision :	A
	Type :	Material :	
	PURCHASED PARTS	Due Date :	30/04/2008
Written By :		Qty:	40
Checked & Approved By :	<u>JD 08.04.4</u>	Um:	Each
Comment :	Est: B 00.06.22 Added receiving step & removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 6080

Cast per Dwg D2855

Material Release Note Required

C208/04/07

(40)

2.0	D2855P	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)
 CAP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

P 8/5/12 (40)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

count
5 08/05/12 (40)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Drill as per Dwg D2855 using DT8235

2- Open holes to 19/64"

3- Deburr

C208/05/13 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 04/04/2008 9:22:03 AM
User: Julie Lecocq

Process Sheet

30 min

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

14/05/2008

Job Number: 38395

Part Number: D2855

S.242 07.20

Job Number:



#1 320.7 F

#2 02855 F

#3 038395 F

#4

Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/13 (40)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Fd 08/05/14 (40)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-L

08/05/14

(40X)

9.0

ALS71032225

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 80.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

2 ALS7-1032-225 Insert

or AKS7-1032-225

or ALS4-1032-225

or AKS4-1032-225

M100489

M-L

(40X)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Inserts as per Dwg D2855

M-L

08/05/14

(40X)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/14 (40)

count

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

F-P 22

M-L 08/05/14

(42X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 04/04/2008 9:22:03 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 38395

Part Number: D2855

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/14 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08-05-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

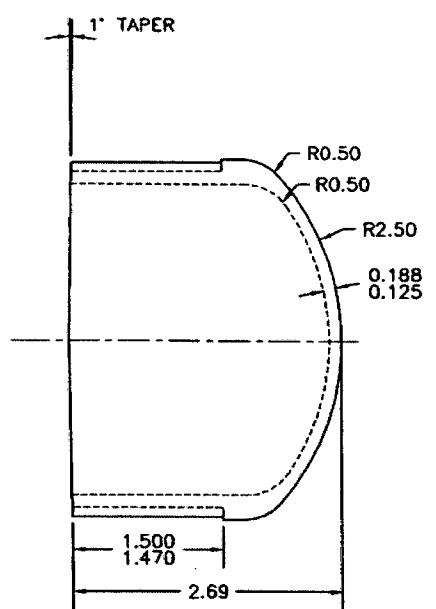
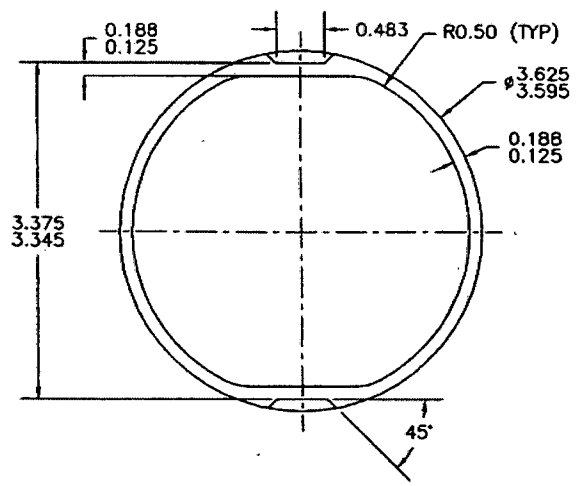
DART



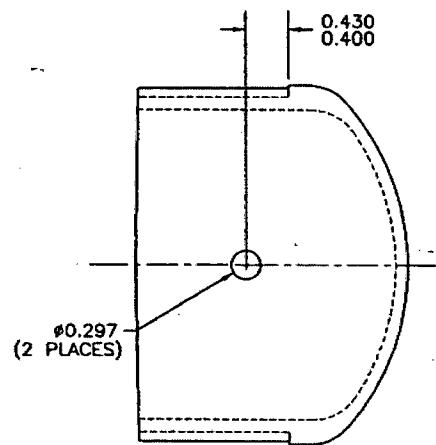
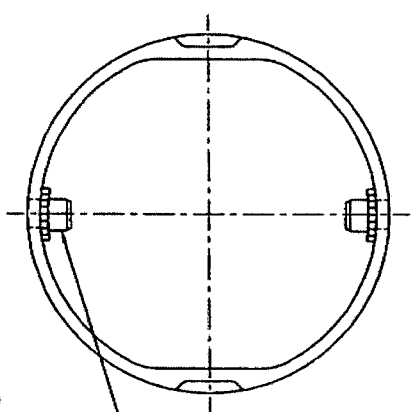
DESIGN #	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D2855	SHEET 1 OF 1
98.12.12		TITLE	SCALE
		CAP	NTS
A	96.12.12	NEW ISSUE (WAS D2575 REV. E)	

RELEASED
98.12.14 DS

D2855 CASTING DETAIL



D2855 FINISHING DETAIL



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP (AFTER POWDER COAT) (2 PLACES)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
MATERIAL: CAST ALUMINIUM ALLOY A356.2 (F)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38395

Aluminum Foundry Ltd

714-716 Calais
Dorval, Québec H9P 2P3
Tel: (514) 631-1331
Fax: (514) 631-8448

Packing Slip

Packing Slip No.: 32553
Date: May 09, 2008
Page: 1

Sold to:	Ship to:
DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7	DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7
Order No.: 00006080	Sold By:
Shipped By: FEDEX	Ship Date: May 09, 2008
Tracking No.:	

Item No.	Unit	Description	Quantity
Z098046	Each	D2855 CAP REV.A <i>100 CFRT</i>	40
Comment:			

*Attn. Chautal*7CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCEFONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD714-718 CALAIS, DORVAL, QC H9P-2P3
TEL : (514) 631-1331 FAX: (514) 631-8448Expédié à
Shipped

DART AEROSPACE

A.F. & P.W.Série no./Serial no.

1270 Aberdeen Street

Packing
Date: 09/05/2008 Slip No. 32554

Hawksbury, ON, K6A 1K7

Vôtre No. Commande 00006080
Your order No.

Ceci est pour certifié que le materiel liste ci-dessous est selon les specifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificats de détaillante sont en filiere dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantite Quantity	Description	Notre No. Our No.	Specifications	Note d'autorisation Incoming Release note
40	D 2855 CAP	Z098046	A356.2	Ingot#850156

Analyse
Analysis (as in Ingot)

(Si)	7.00%	(Al)	balance
(Fe)	0.08%		
(Cu)	0.00%		
(Mn)	0.00%		
(Mg)	0.40%		
(Zn)	<0.01%		
(Ti)	0.18%		

Donne
Yield :Résistance à la tension :
Tensile Strength :Allongement par pouce carré :
P.S.I. Elongation :

%

Pour et au nom de
For and on behalf of :FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTDDept/Dep :
Par/Per :

Coc-100